



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4855-1
Job Sheet 170116



Part No: D4855-1

Job Qty: 10 ea

Part Name: Antenna Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Lohman Helicopter LLC (CLOHM01)

PO Box 976 Lewiston, ID, 83501 USA ph:(208) 743-5411 fx:(208) 413-9444.

Note: DWG REV A SHEET 1 IPP REV: A NEW ISSUE JFS 13/06/26 VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Machining-3		SL 18/01/29
100	Bandsaw	10 pcs	1/25/18	1/25/18	0.00	0.28	Bandsaw1		SL 18/01/29
110	CNC Vertical Machining	10 pcs	1/25/18	1/25/18	0.29	8.77	HAAS1-5		SL 18/01/29
130	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC8 Machining-3		SL 18-01-31
140	HandFinish	10 pcs	1/25/18	1/25/18	0.00	0.40	HandFinish1		18-01-31
150	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC7-4		18-02-01
160	Powdercoat	10 pcs	1/26/18	1/26/18	0.00	0.20	Powdercoat1		18-02-01
170	QC	10 pcs	1/26/18	1/26/18	0.00	0.00	QC3		11 FEB 05 2018
180	Packaging	10 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-2		9-89 STS26
190	QC21-SA	10 Ea	1/26/18	1/26/18	0.00	0.00	QC21		DAS 21 FEB 05 2018

Part Op 100 - CUT BLANK AT 3.000"
Descriptions: 110 - 1-Machine per folio FB200
160 - START TIME: 3.20
CUT: 3.20
FINISH: 3.50
FAB 18-01-31
5029779 = 1' (4x)
5036064 = 1.5 (6x)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B4.500X4.500	3	4	0	0

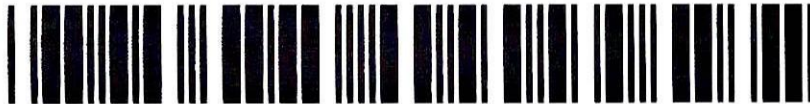
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Antenna Bracket	0.875Inches ± 0.010	0.885 0.865		0.869
2	Antenna Bracket	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter	0.201
3	Antenna Bracket	0.970Inches ± 0.030	1.000 0.940		0.970
4	Antenna Bracket	0.970Inches ± 0.030	1.000 0.940		0.970
5	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850		1.876
6	Antenna Bracket	3.750Inches ± 0.030	3.780		3.750

DART
AEROSPACE
S036580

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Antenna Bracket

PART NO: D4855 – 1

Original Serial #: S036580

Revision:

Operation: Start up Operation 01/29/18

Change No:

Job No: 170116

			3.720		
7	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius	.250
8	Antenna Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	0.257
9	Antenna Bracket	2.130Inches ± 0.030	2.160 2.100		2.126
10	Antenna Bracket	1.400Inches ± 0.030	1.430 1.370		1.400
11	Antenna Bracket	1.260Inches ± 0.030	1.290 1.230		1.242
12	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850		1.870
13	Antenna Bracket	0.280Inches + 0.006 - 0.001	0.286 0.279	Diameter	.280
14	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	Radius	.380
15	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	Radius	.380
16	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius	.250
17	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240		.248
18	Antenna Bracket	2.500Inches ± 0.030	2.530 2.470		2.500
19	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240		.249
20	Antenna Bracket	4.250Inches ± 0.030	4.280 4.220		4.253
21	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	Radius	.250

Plex 1/10/18 12:29 PM Dart.lajeunesse.marie